

5/15

DART AEROSPACE LTD		Work Order:	22937
Description: Pedal Lock Cover <i>Hand RULLED</i>		Part Number:	D3368-3
Dwg: D3368 Rev. A		Qty:	4
		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	<i>[Signature]</i>	05.04.07	4
2	MV	Cut blank: 2.00" x 2.00" x 10.450" long Material: 6061-T6 Bar (QQ-A-225/8 or QQ-A-200/8) (M6061T6B2.000x02.000) Identify for D3368-3 Batch: <u>M17124</u>	<i>[Signature]</i>	05/04/12	4
3	MV	Machine D3368-3 as per Folio FA500 and Dwg D3368 Identify as D3368-3	<i>[Signature]</i>	05/04/13	4
4	QC2	Inspect parts as they come off the CNC machine	<i>[Signature]</i>	05/04/13	4
5	QC8	Second check	<i>[Signature]</i>	05/04/13	4
6	MV	Deburr	<i>[Signature]</i>	05/04/13	4
7	QC5	Inspect work to Step 6	<i>[Signature]</i>	05/04/13	4
8	FP	Chemical Conversion Coat as per QSI 005 4.1	<i>[Signature]</i>	05.04.13	4
9	FP	Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3	<i>[Signature]</i>	05.04.14	4
10	QC3	Inspect Powder Coat	<i>[Signature]</i>	05.04.15	4
11	ST	Identify and Stock	<i>[Signature]</i>	05.04.15	4
12	AC	Cost / part <u>57.45</u>	<i>[Signature]</i>	05.04.19	4
13	DC	Close W/O <u>53.92</u> Inspect Level 21	<i>[Signature]</i>	05.04.20	4

Pto

Rev	Date	Change	Revised By	Approved
A	05.01.27	New issue	KJ/JLM	<i>[Signature]</i>

RELEASED
[Signature] 01/01/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/04/13	3	Drilled hole x2 too deep Hole position changed for new hinge (1) BASE (1) COVER	TH 05.04.13	Weld + grinded cosmetic DRAWING D3368 HAS BEEN MODIFY TO CORRECT THE PROBLEM. SEE DWG. D3368 REV. B TH 05.04.13	TH 05.04.13	TH 05.04.13	TH 05.04.13	TH 05.04.13

Part No: D3368-3

PAR #: _____

Fault Category: _____

NCR: Yes

No

DQA: 19Date: 05/04/13

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3368	REV. A SHEET 1 OF 3
DATE 05.01.19		TITLE PEDAL LOCK	SCALE 1:3
A	05.01.19	NEW ISSUE	

RELEASED
[Signature]

05/02/22

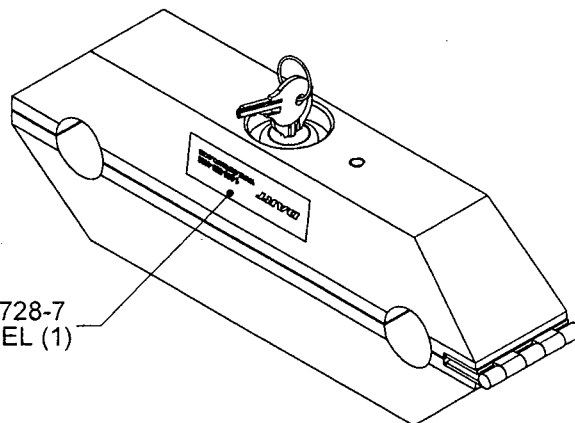
CANCEL ~~RE~~ 05.04.09

UNDER REVIEW

~~RE~~ 05.03.22

WEIGHT REDUCTION
+ HINGE CHANGE

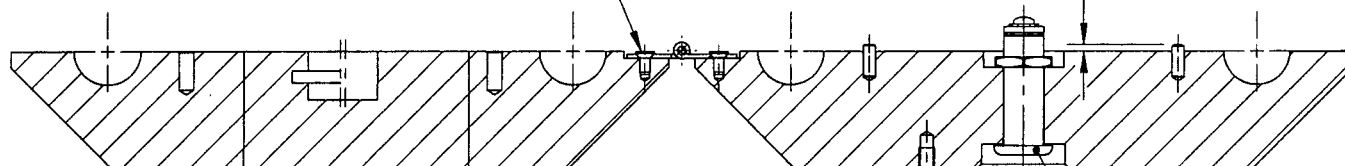
D2728-7
LABEL (1)



PEDAL LOCK SHOWN LOCKED WITH KEY

1 MACHINE SCREW #8-32 x 0.313 LONG,
(4 PLACES)

0.100
(2 PLACES)

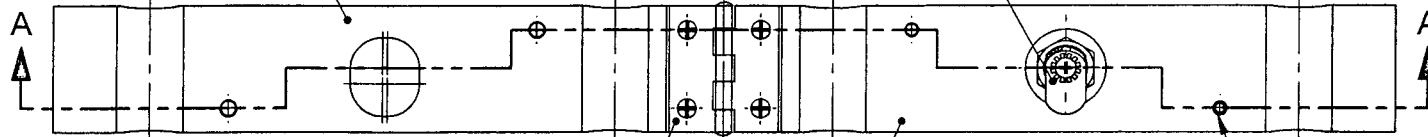


SECTION A-A

D3373-7 CAM
LOCK ASS'Y

D3368-1 BASE (1)

D3371-5 CAM (1),
SQUARE WASHER SPACER (1),
EXTERNAL TOOTH LOCK WASHER (1),
#10-32 UNF PAN CROSS HEAD SCREW (1),
(AS PER D3373-1)



D3385-1 HINGE (1)

D3368-3 COVER (1)

STD. GROUND DOWEL
PIN $\varnothing 3/16$ x 0.50 LONG
(2 PLACES)

SHOP COPY

RETURN TO
ENGINEERING

D3368-051 PEDAL LOCK ASSEMBLY

NOTES:

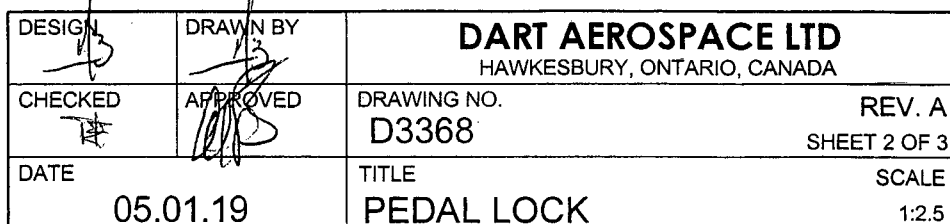
- 1) POSSIBLE SUPPLIER: SPAENAU P/N 385-039
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

UNCONTROLLED COPY
REVISION
DATE

ORDER
NO. 22937

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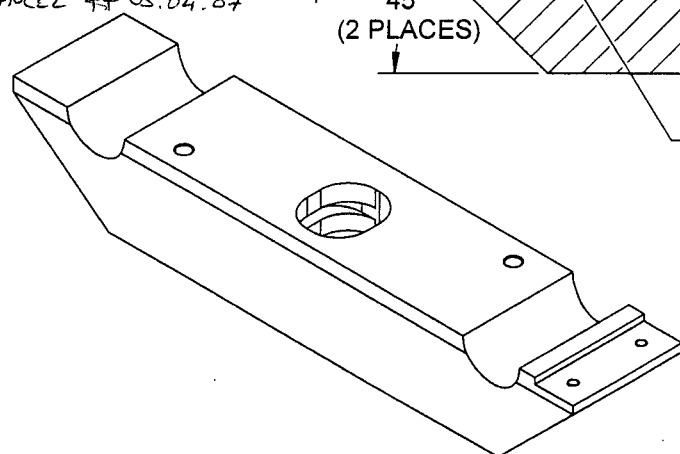


05/06/22

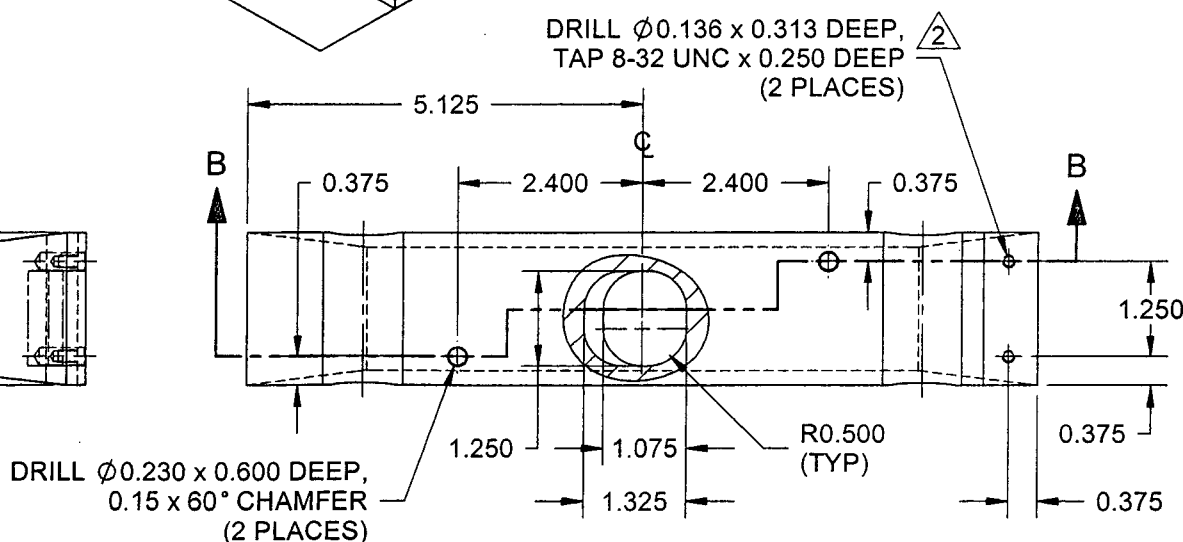
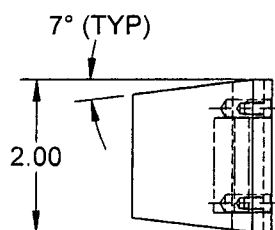
UNDER REVIEW

12/05.03.22

CANCEL ~~FF~~ 05.04.07



SECTION B-B



D3368-1 BASE

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
2) COVER INSIDE HOLES PRIOR PAINTING
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4:1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES
6) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY

RETURN TO ENGINEERING

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4.1
005 4.3
E NOTED

WORK ORDER

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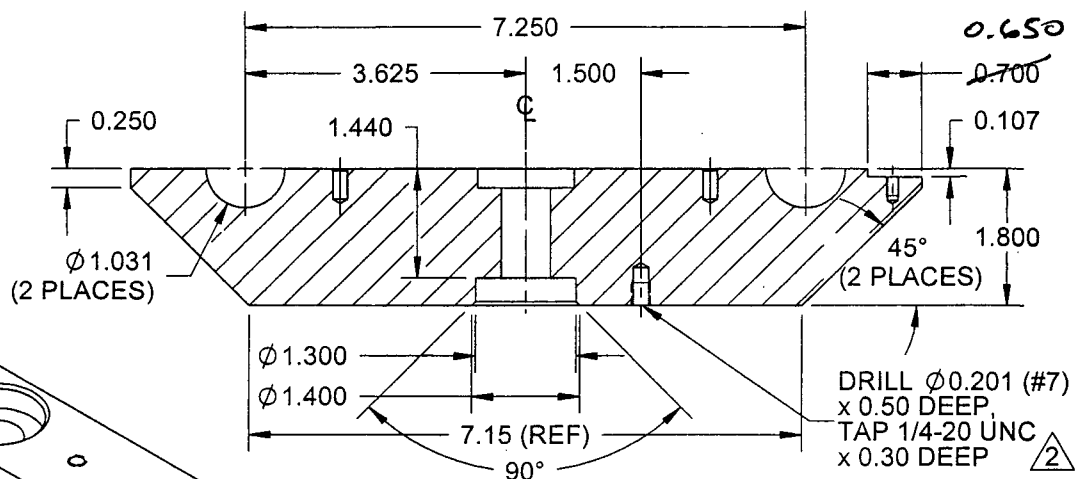


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3368	REV. A SHEET 3 OF 3
DATE 05.01.19	TITLE PEDAL LOCK		SCALE 1:2.5

05.04.12

RELEASED
[Signature]

05/02/22

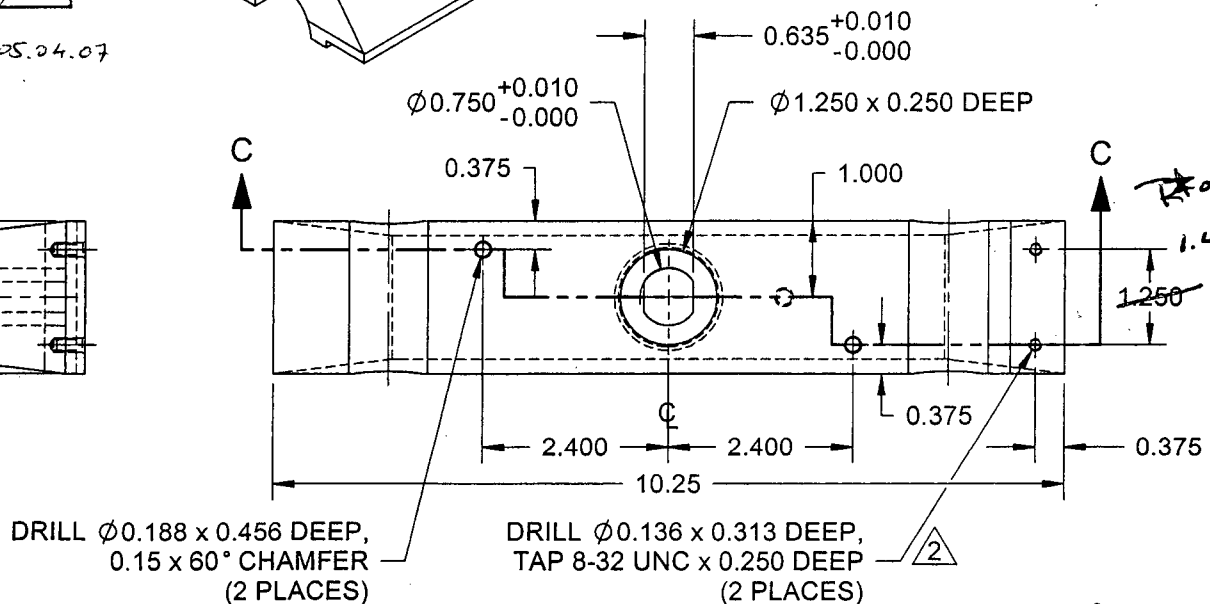
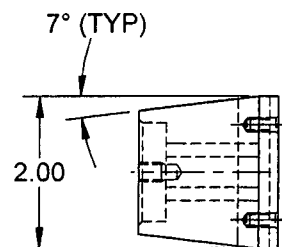


SECTION C-C

UNDER REVIEW

05.03.22

CANCEL *05.04.07*



D3368-3 COVER

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY
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FOR NOTICE

ORDER
NO. *22937*

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Apr 07, 2005
10:55 am

Work Order No : 0022937
Project Name : D3368-3
Project For : WK515
Work Order Type : Main
Main WO Number :
House Part Number : D3368-3
Description : Pedal Lock Cover
Manufactured : Yes
Amount Req'd : 4
Amount Done : 0
Start Date : 04-07-05
Est Finish Date : 04-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

DART AEROSPACE LTD		Work Order:	22937
Description: Cover, Pedal Lock		Part Number:	D3368-3
Inspection Day: D3368	Rev:	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.250	$\pm .010$.250	✓			
7.250	$\pm .010$	NA				
3.265	$\pm .010$	NA				
1.500	$\pm .010$	1.494	✓			
.650	$\pm .010$.651	✓			New hinge
.107	$\pm .010$.106	✓			
1.800	$\pm .010$	1.795	✓			
Ø 1.300	$\pm .010$	1.307	✓			
Ø 1.400	$\pm .010$	1.400	✓			
7.15	$\pm .03$	7.150	✓			
Ø 1.031	$\pm .010$	NA				
Drill Ø .201 X .52	✓	✓				
Tap 1/4-20 X .32						
2.00	$\pm .030$	1.986	✓			
Ø .750	$\pm .010$ $-.000$.750	✓			
.375	$\pm .010$.372	✓			
.635	$\pm .010$ $-.000$.637	✓			
Ø 1.250	$\pm .010$	1.255 ^{X.248}	✓			
.250 deep	$\pm .010$					
1.000	$\pm .010$	1.000	✓			
1.450	$\pm .010$	1.450	✓			changed from 1.250
.375 → .310	$\pm .010$.310	✓			changed
.375 → .275	$\pm .010$.275	✓			changed
10.250	$\pm .03$	10.252	✓			
2.4 X 2	$\pm .010$	✓				

~~Ø 1.188 X .556 deep~~ ~~1.188~~

Measured by: B.G.	Audited by: Ep	Prototype Approval:
Date: 05/04/12	Date: 05/04/12	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	